

Work Order ID 128110

January-07-15 11:14:33 AM

128110

EUROCOPTER
FEB 27

Page 1

Item ID: D350-591-311

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Stop

NS2

Start Date: 1/07/15 Start Qty: 5.00

5

Cust Item ID:

Required Date: 1/30/15 Req'd Qty: 5.00

5

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3272	Rev B

100

Document Control

0.00

DAS

06

9-89

100

DC

Doc.Control -USB or Paperwork

DOCUMENT CONTROL

Memo

0.00

Photocopy bluefile and type labels as per PPP D350-591-311 CHG002
ATTN: CHG002 - NON EUROCOPTER

5x

DAS

46

9-89

FEB 18 2015

110

110

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg
D3272

A/RAluminum Rod 1130855

3-Grind End Plate flush

5

JAN 26 2015

DAS

24

9-89

CC 15-1-27

Work Order ID 128110

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Page 3

Item ID: D350-591-311
 Revision ID:
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 1/07/15 Start Qty: 5.00
 Required Date: 1/30/15 Req'd Qty: 5.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC7-Inspect Chemical Conversion Coat	0.00				⑤			DAS 38 9-89
150									
QC	Memo	0.00							15-01-04
Quality Control									
180		0.00							
180									
Large Fab									
Large Fab									
	Memo	0.00							
	1-Assemble Leg Assembly as per Dwg D3272.								
	2-Leave one rivet out until welding is complete.								
	3-Bevel Aft end for welding								
	4-Inspect for foreign object as per QSI 024								
	5-Weld Aft End Plate as per QSI 004 & Dwg D3272 A/RAluminum Rod 4128956								
	6-Grind End Plate flush								
	7-Install last rivet as per Dwg.								

5X

04/15/2/5

5X

DAS
43
9-89

FEB 07 2015

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128110

Page 4

Accept

N900040100

Setup Start *NS1*

Revision ID:

Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Stop *NS2*

Start Date: 1/07/15 **Start Qty:** 5.00 ***5***

Cust Item ID:

Required Date: 1/30/15 **Req'd Qty:** 5.00 ***5***

Customer:

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

[illegible]

Work Order ID 128110

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Page 5

Item ID: D350-591-311
 Revision ID:
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 1/07/15 Start Qty: 5.00
 Required Date: 1/30/15 Req'd Qty: 5.00
 Reference:

Accept

N900040100

Setup Start ***NS1***
 Stop ***NS2***

Cust Item ID:
 Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***
 Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
220	<i>17129808.</i>					<i>5</i>	<i>0</i>	<i>15-2-10.</i>	<i>238</i>
Powdercoat	Memo	0.00							
Powder Coating	START TIME: <i>2:10.</i> OVEN TEMPERATURE: <i>320</i> FINISH TIME: <i>2:40.</i>								
230	Wing Walk as per dwg QSI005 4.4 Batch <i>111309800</i>								
230									
HandFinish	Memo	0.00							
Hand Finishing									
240	QC3- Inspect Part Finish	0.00							
240									
QC	Memo	0.00							
Quality Control									

X56H d 15/02/11

(5) **DAS 38 9-89**
FEB 11 2015

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
 Start Date: 1/07/15 Start Qty: 5.00 ***5*** Cust Item ID:
 Required Date: 1/30/15 Req'd Qty: 5.00 ***5*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
250	Pick Kit	0.00							
250									
Packaging	Memo	0.00							
Packaging									
260	QC4- 100% Inspect kits for completeness	0.00							
260									
QC	Memo	0.00							
Quality Control									
270	Packaging	0.00							
270									
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPD350-591-311								
	Location: <u>084</u>								

5x
 DAS 27 9-89
 FEB 18 2015
5x
 DAS 46 9-89
 FEB 18 2015
5x
 DAS 46 9-89
 FEB 18 2015

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Item ID: D350-591-311 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible
Start Date: 1/07/15 Start Qty: 5.00 ***5*** Cust Item ID:
Required Date: 1/30/15 Req'd Qty: 5.00 ***5*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
280	QC21- Final Inspection - Work Order Release	0.00							
280									
QC	Memo	0.00							
Quality Control									

MLJ 15-02-23

MF 15-2-20

January-07-15 11:14:29 AM

128110

D350-591-311

Required Date: 1/30/15

Required Qty: 5.00

Comments: IPP Rev:A04.03.22New issue KJ/RF
IPP Rev:B 07-06-09 Added D3272-1 JLM
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified
by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
DSI 9410-011		Manufactured	No				Each	0.0000		5		DAS 27 9-89	14
DSI 9410-011 Amends Installations Of D350-591-311/312 Steps													
D3272-1		Manufactured	No			110	Each	0.0000	1	5		DAS 24 9-89	JAN 26 2015
D3272-1 Step													
D3067-1		Manufactured	No			110	Each	139.0000	1	5		DAS 24 9-89	JAN 26 2015
D3067-1 End Plate													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA003			139						
				117776			1						
				119290			138						
D3219-1		Manufactured	No			110	Each	57.0000	2	10		DAS 24 9-89	JAN 26 2015
D3219-1 Plate													
				<u>Location</u>			<u>Loc Qty</u>		<u>Loc Code</u>				
				WA003			57						
				115339			44						
				124869			13						

Picklist Print

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Work Order ID: 128110

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

D3066-1 Manufactured No 180 Each 33.0000 2 10

D3066-1

Spacer

**

DL 15/2/5

Location	Loc Qty	Loc Code
WA003	33	
106302	1	
125436	32	

MS20600-AD4W4 Purchased No 180 Each 1,006.000 16 80

MS20600-AD4W4

Rivets

**

DL 15/2/5

Location	Loc Qty	Loc Code
ST309	1006	
M128899	1006	

D3065-041 Manufactured No 180 Each 13.0000 1 5

D3065-041

Step Leg Assembly

**

DL 15/2/5

Location	Loc Qty	Loc Code
WA003	13	
122273	13	

D3067-1 Manufactured No 180 Each 139.0000 1 5

D3067-1

End Plate

**

DL 15.2.5

Location	Loc Qty	Loc Code
WA003	139	
117776	1	
119290	138	

Picklist Print

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Work Order ID: 128110

128110

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

AN3-35A

Purchased No

250 Each

57.0000

2 10

AN3-35A
Bolt

DAS
46
9-89

**

DAS
27
9-89
FEB 17 2015

Location

Loc Qty

Loc Code

FG

10

122800

10

ST348

47

m130466

47

D3235-1

Manufactured No

250 Each

153.0000

2 10

D3235-1
Mounting Lug

DAS
46
9-89

**

DAS
27
9-89
FEB 17 2015

Location

Loc Qty

Loc Code

ST522

55

108670

24

114441

24

116384

1

116385

6

ST539A

98

116383

98

D3278-041

Manufactured No

250 Each

48.0000

1 5

D3278-041
Support Assembly

DAS
46
9-89

**

DAS
27
9-89
FEB 17 2015

Location

Loc Qty

Loc Code

ST523

48

123337

30

125102

18

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Shop Packet Print

Page 3

Picklist Print

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0463J

Purchased

No

250

Each

5,835.000

16

80

DAS

27

9-89

FEB 17 2015

NAS1149D0463.J

WASHER

46

9-89

Location

Loc Qty

Loc Code

CA

397

M129682

397

GA

408

M129390

408

ST260a

1153

M129390

1153

ST269

3877

M129390

12

M130799

3865

80

NAS1149D0563J

Purchased

No

250

Each

1,983.000

4

20

DAS

27

9-89

FEB 17 2015

NAS1149D0563.J

Washer

46

9-89

Location

Loc Qty

Loc Code

GA

130

m125807

130

ST260a

400

m130799

400

ST269

453

m128257

453

ST271

1000

m131026

1000

20

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Page 5

Work Order ID: 128110

128110

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

AN5-36A

Purchased

No

250

Each

126.0000

2

10

DAS

27

FEB 17 2015

AN5-36A

Bolt

DAS

46

9-87

Location

Loc Qty

Loc Code

ST299A

125

M130466

125

ST336

1

M130325

1

D2618

Manufactured

No

250

Each

84.0000

2

10

DAS

27

FEB 17 2015

D2618

Bushing

DAS

46

9-87

Location

Loc Qty

Loc Code

ST012a

84

124350

34

125308

50

D2230-3

Manufactured

No

250

Each

192.0000

4

20

DAS

27

FEB 17 2015

D2230-3

Mounting Lug

DAS

46

9-89

Location

Loc Qty

Loc Code

FG

8

109344

4

89045

4

ST521

24

114921

4

116378

20

ST525A

160

123324

160

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Shop Packet Print

Page 5

Picklist Print

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Page 6

Work Order ID: 128110

128110

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

D2856-400

Manufactured No

250 f

108.6400

1.2 6

D2856-400 DAS
Abrasion Strip 4" Wide (Per Foot) 46
9-89

**

DAS

27

9-89

FEB 17 2015

Location

Loc Qty

Loc Code

ST418

108.64

108.64

117887

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased

No

250

Each

570.0000

2 10

MS21042L3 DAS
Nut 46
9-89

**

DAS

27

9-89

FEB 17 2015

Location

Loc Qty

Loc Code

FP001

489

M130922

489

ST305

78

M130799

78

ST307

3

123900

3

AN4-13A

Purchased

No

250

Each

181.0000

8 40

AN4-13A DAS
Bolt 46
9-89

**

DAS

27

FEB 17 2015

Location

Loc Qty

Loc Code

FG

20

122808

20

GA

43

m130325

43

ST325A

118

m130716

118

January-07-15 11:14:32 AM

Shop Packet Print

Page 6

Picklist Print

January-07-15 11:14:32 AM

Page 7

Work Order ID: 128110

128110

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

MS21042L5

Purchased

No

250

Each

552.0000

☐ 2

10

MS21042L5

DAS

46

Nut

9-89

**

DAS

27

FEB 17 2015

Location

Loc Qty

Loc Code

GA

496

m127813

496

ST305

56

m130358

56

m131340

10

MS21042L4

Purchased

No

250

Each

3,662.000

☐ 8

40

MS21042L4

DAS

46

Locknut

9-89

**

DAS

27

FEB 17 2015

Location

Loc Qty

Loc Code

FP001

42

m124231

42

GA

704

m127813

704

ST260a

2000

m130799

2000

ST305

916

426

426

m128300

8

m130922

482

40

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Work Order ID: 128110

128110

Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible

Start Date: 1/07/15

Required Date: 1/30/15

Start Qty: 5.00

Required Qty: 5.00

NAS1149D0363J

Purchased

No

250

Each

1,958.000

4

20

NAS1149D0363J

DAS

46

Washer

9-89

DAS

27

FEB 17 2015

Location

Loc Qty

Loc Code

CA

673

m130799

673

FP001

154

m126319

154

GA

778

m128429

778

ST269

353

122378

254

m126319

99

4



DESIGN <i>90</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG SCALE NTS	
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

△
B

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

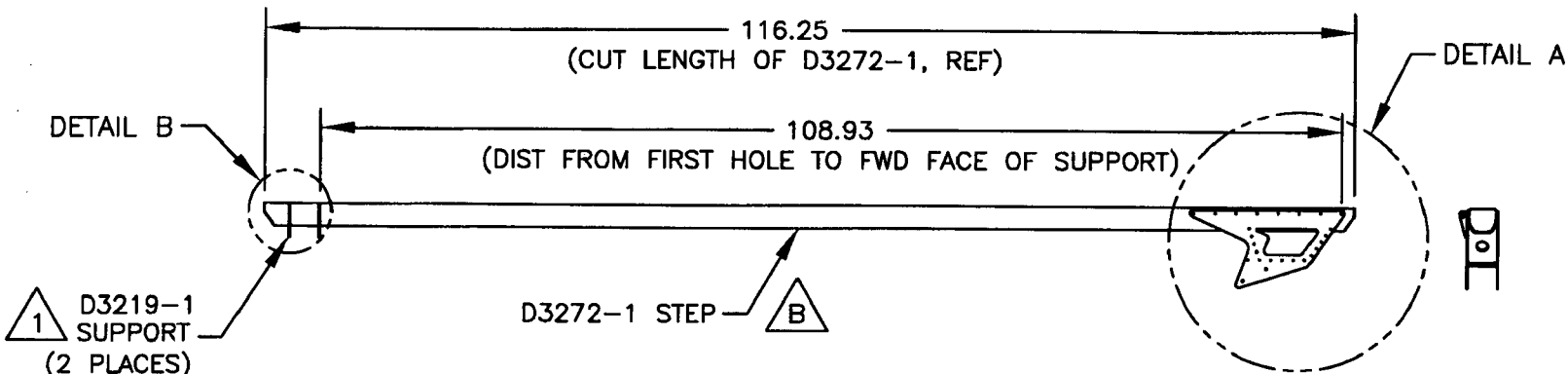
Mfg 1289

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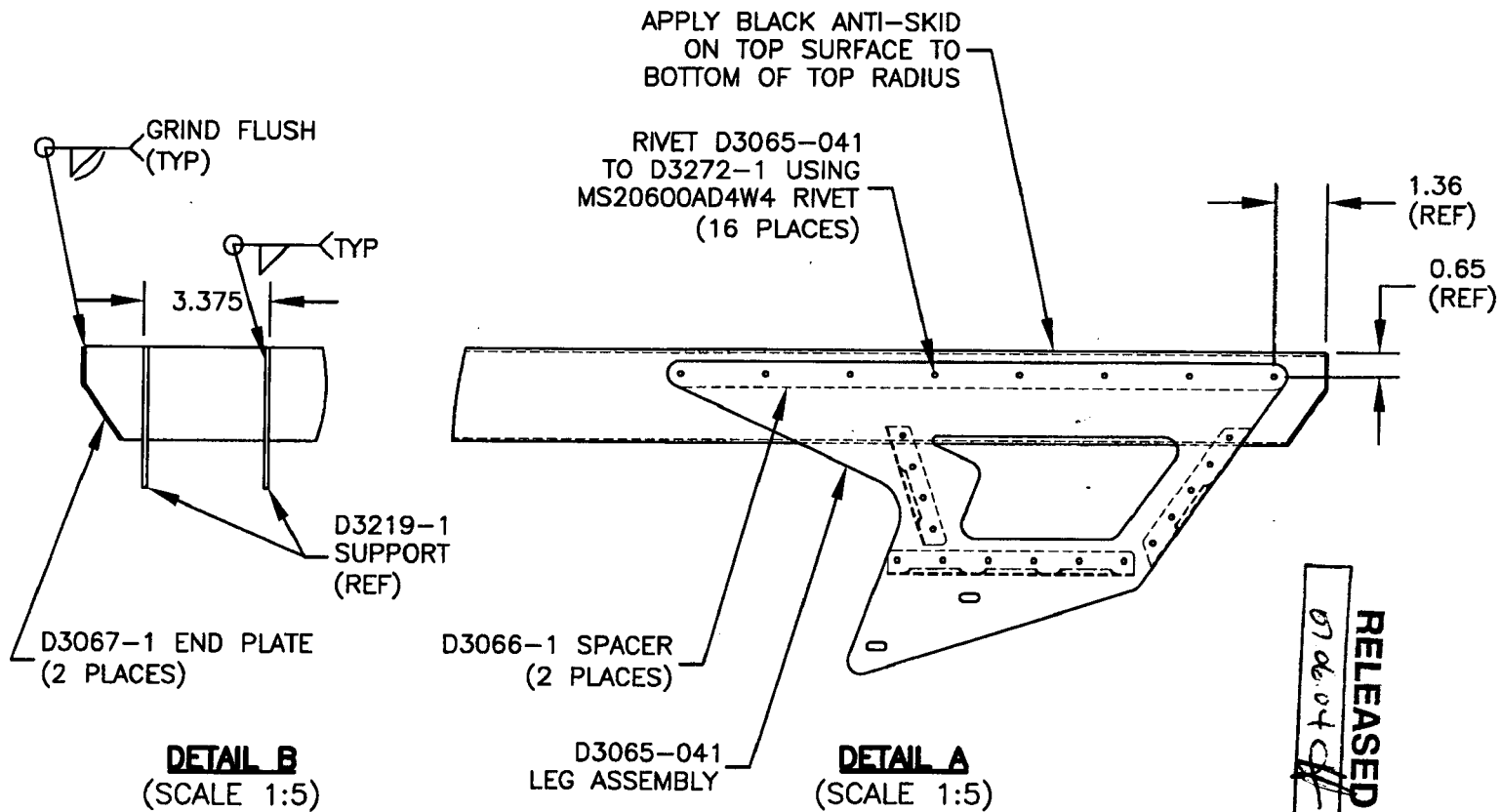
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DESIGN	90	DRAWN BY		DART AEROSPACE LTD
CHECKED	CE	APPROVED		HAWKESBURY, ONTARIO, CANADA
DATE	07.05.18	DRAWING NO.	D3272	REV. B
		TITLE	STEP ASSEMBLY, HI LONG	SHEET 2 OF 3
		SCALE	1:20	



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



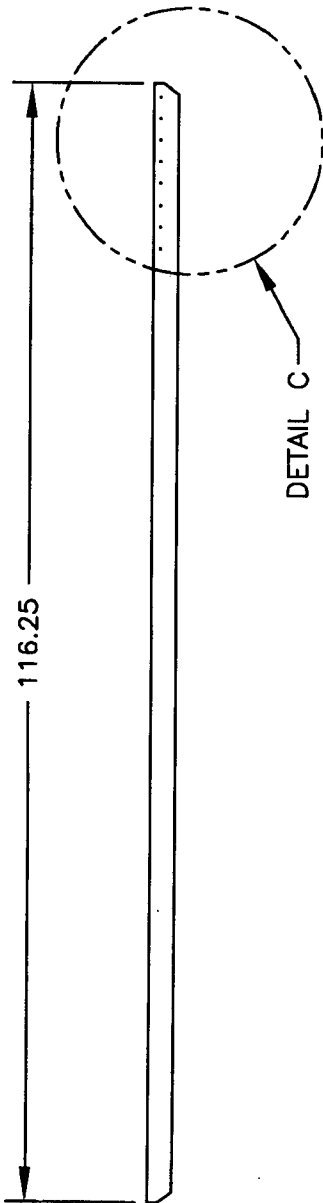
RELEASED
07.06.04



DESIGN <i>GP</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

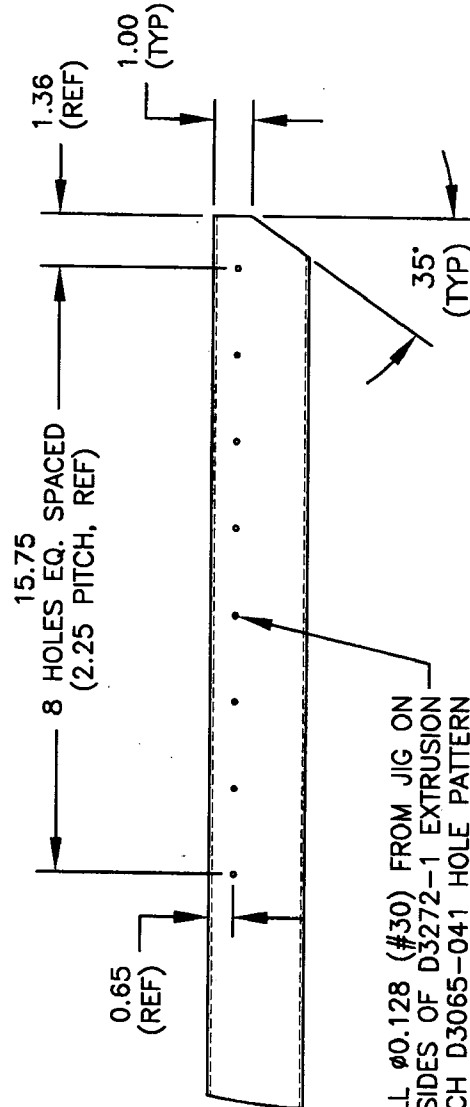
07.06.04 *[Signature]*



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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